

Work Order ID 56314

February 17, 2010 2:35:42 PM



Page 1

Item ID: D3766-3

Accept



Setup Start



Revision ID:

Item Name: Rear Rail

Stop



Start Date: 2/17/10 Start Qty: 8.00



Cust Item ID:

Required Date: 2/17/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-2-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3766

Rev B

0.00

100



Small Fab

0.00

Small Fab

Memo

0.00

1-cut tube to lenght as per dwg D3766. 2-drill holes thru to finish size as per dwg D3766 using DT9413 ,Drill holes labelled #3.. 3-deburr

(8X)

=> M. L 10/03/08

Pb →

110



QC5- Inspect part completeness to step on W/O

0.00

S 10/03/10

QC

Memo

0.00

Quality Control

(X8)

120



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

M 10/07/10

(X8) O

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3766-3 PAR #: Fault Category: Stress/crevicing NCR: Yes No DQA: Date: 10/03/10
 Resolution: Scraps Disposition: Scrap QA: N/C Closed: Date: 10/04/12

NCR: 56314		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/10	#100	Found by employee /Frobach - length of Bar with the inside wall thickness P varying to size to size R.L. sulphur.	✓ 563142	Scrap total length (1 bar) of Bar. to prevent it from coming in to the Floor again. Certs will run since it with note to be sent back	SB 10/03/10	S 10/03/10	✓ 10/04/12	S 10/03/10
		① what the Bar looks like - a Bar was received in but was scrapped to be	✓ 10/04/12	M11186 = Again CoG/16 1.00 ± .188w "			✓ 10/04/12	S 10/03/10
		marked as Radius/Scrap	✓ 10/04/12					S 10/03/10

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 2/17/10 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

i30



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

PR

Draw
Number

10 -3-10

Draw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Packaging

Packaging

Identify as per dwg & Stock Location: 264

0.00

0.00

R10/3/11 8

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/03/11 JF
MR
10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Mormon

Page 1

Picklist Print

February 17, 2010 2:35:47 PM

Work Order ID: 56314



Parent Item: D3766-3



Parent Item Name: Rear Rail

Start Date: 2/17/10

Required Date: 2/17/10

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC
IPP Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/

Replacement

Mfg/
Purchased

Bin

Primary

Last

Route

Unit of

Qty on

Remaining

Qty

Date

Status

M6061T6T1.000W.188



6061T6 RD TUBE 1.00 X .188W

Warehouse	Loc Qty	Loc Code
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Location

Main Warehouse

MAT	74.5934542	
109041	1.03	
112529	20.5647542	
113511 ✓	51.3987	
18101	1.6	

M111885 ✓
MN11885 ✓

3 X 8.81904
4 X 11.75872
1 X 2.93968

M-t
10/03/04

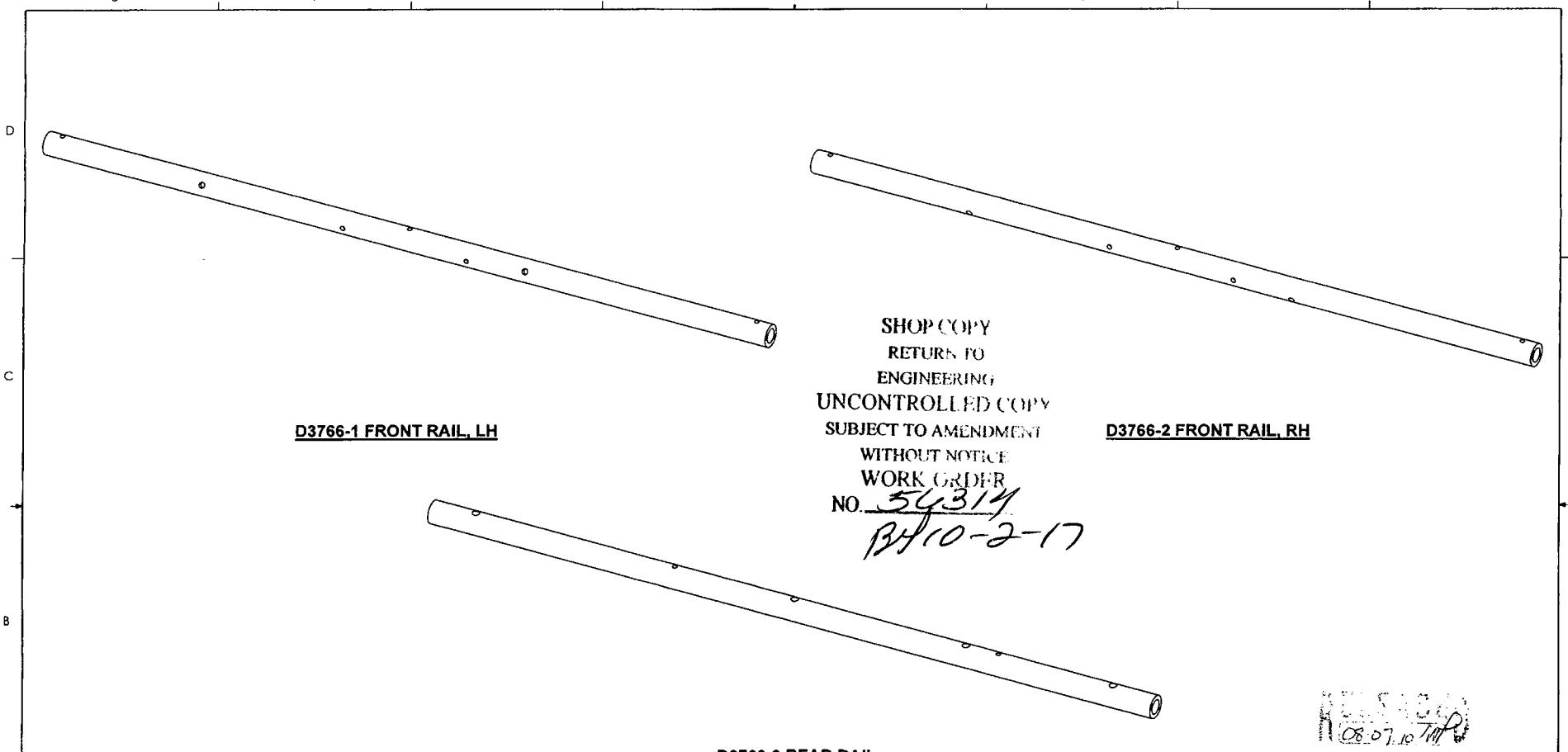
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 54314*B410-2-17*

NOTES:

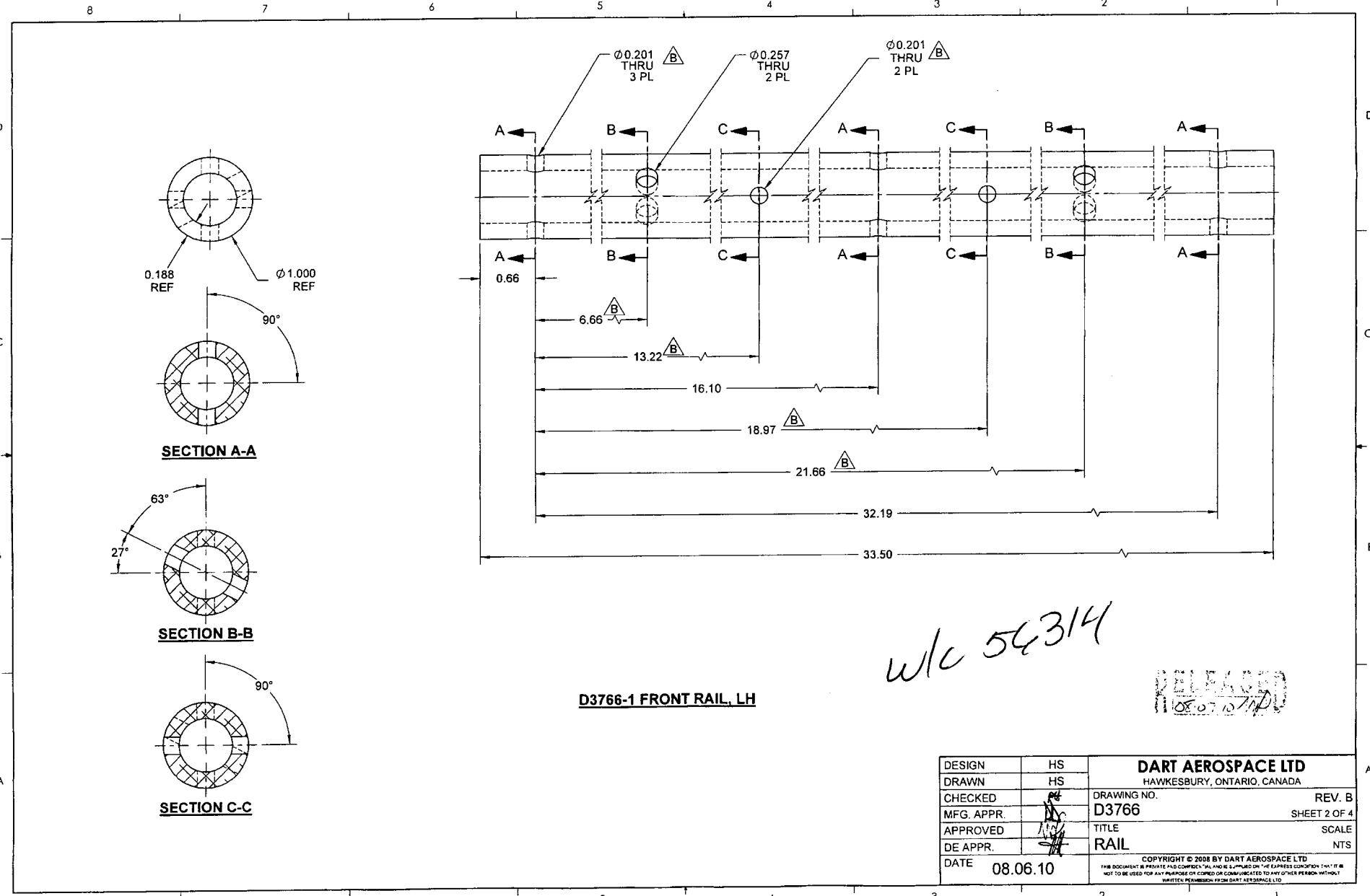
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

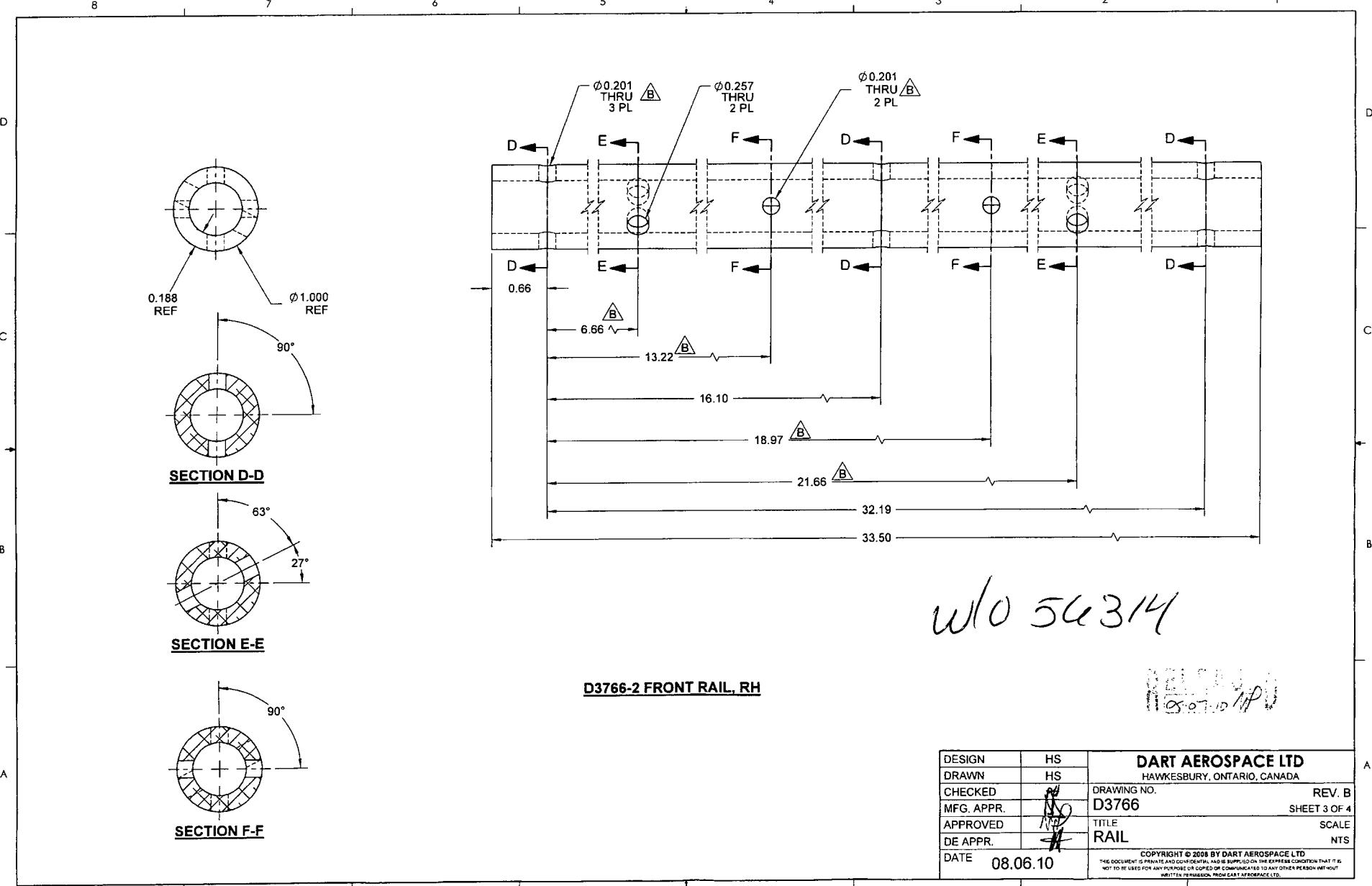
8 7 6 5 4 3 2 1

B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125		HS	08.06.10
A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D3766 SHEET 1 OF 4	REV. B TITLE SCALE NTS
DRAWN	HS			
CHECKED	<i>RD</i>			
MFG. APPR.	<i>M</i>			
APPROVED	<i>MD</i>	DATE 08.06.10	TITLE RAIL	SCALE NTS
DE APPR.	<i>SP</i>			

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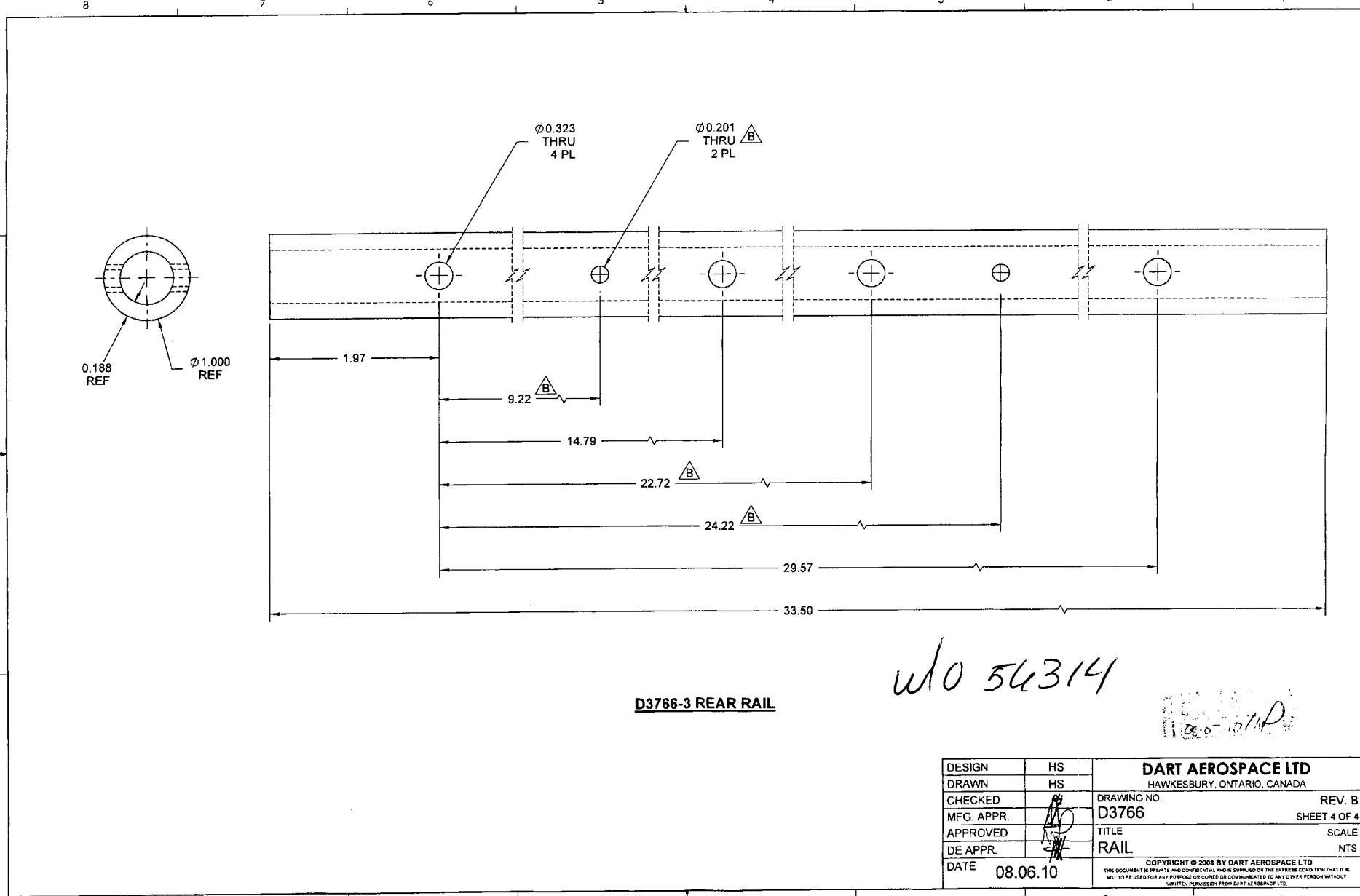
8 7 6 5 4 3 2 1





DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	REV. B	
MFG. APPR.	✓	D3766	
APPROVED	✓	SHEET 3 OF 4	
DE APPR.	✓	TITLE	SCALE
DATE 08.06.10		RAIL NTS	

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